



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2274

Job Sheet 180963



Part No: D2274

Job Qty: 100 ea

Part Name: Radius Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Large Fab-7		21/07/18
100	Shear	100 pcs	8/3/18	8/3/18	0.00	0.05	Shear		"
110	CNC Vertical Machining	100 pcs	8/3/18	8/3/18	0.01	2.39	HAAS 1		
130	QC	100 pcs	8/3/18	8/3/18	0.00	0.00	QC8		21/07/18
140	Small Fab	100 pcs	8/3/18	8/3/18	0.00	0.54	Small Fab		SC 18/08/18
150	HandFinish	100 pcs	8/3/18	8/3/18	0.00	0.26	HandFinish1		SA 18-08-02
160	QC	100 pcs	8/3/18	8/3/18	0.00	0.00	QC7	68-6	15-05-02
170	Packaging	100 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3	9	
180	QC21-SA	100 Ea	8/3/18	8/3/18	0.00	0.00	QC21	9-89	AUG 08 2018

Part Op 100 - blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
Descriptions: 110 - Machine as per folio D2274
140 - Tumble Deburr any rough edges after tumbling

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.125	6061-T6 Bar .750 X .125	8.3000 ft (.083 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X00.125	8	61	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

6

Radius Block

0.063inches $\pm$ 0.010

0.073

0.053

Plex 7/18/18 11:14 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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